

Sept 1

Dart Aerospace Ltd.

Date: Tuesday, 15/08/2006 7:20:01 AM  
User: Linda Lacelle

Process Sheet

SPLIT-2

Customer : CU-DAR001 Dart Helicopters Services  
Job Number : 28189  
Estimate Number : 10578  
P.O. Number : N/A  
This Issue : 15/08/2006 S.O. No. : N/A  
Prsht Rev. : NC  
First Issue : N/A Type : MACHINED PARTS  
Previous Run : 27799  
Written By : W  
Checked & Approved By : W  
Comment : A 05.09.27 New issue EC

Drawing Name : CLEVIS  
Part Number : D34533  
Drawing Number : D3453 REV A  
Project Number : N/A  
Drawing Revision : A  
Material : N/A  
Due Date : 31/08/2006 Qty: 6 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304R1250 Inventory



Comment: Qty.: 0.2452 f(s)/Unit Total : 2.4520 f(s)  
Material: AISI 304 SS Round Bar Ø1.250  
(M304R1.250)  
Batch: M101549 29"

MS 06/09/02

2.0 HARDINGE HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL  
1-Turn as per Folio FA578 Rev: A & Dwg D3453 Rev: A  
2- Deburr as per dwg D3453  
new, folio to be made

MS 06/09/02

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

MS 06/09/02

4.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1  
1-Mill as per Folio FA578 Rev: AA & Dwg D3453 Rev: A  
2- Deburr as per dwg 3453

MS 06/09/07



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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLEVIS

Job Number: 28189

Part Number: D34533

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*ML 06/09/07*

*5*

6.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE  
1- Drill as per dwg D3453

2-Deburr as per dwg D3453

*ML 06/09/07*

*5*

*PTG*

7.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*ML 06/09/07*

*5*

8.0

QC8

SECOND CHECK



Comment: SECOND CHECK

*J.L 06/09/07*

*5*

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Identify and Stock  
Location: *57438*

*U 06/09/11*

*(5)*

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL  
Inspection Level 21

*U 02/09/11*

*(5)*

Job Completion



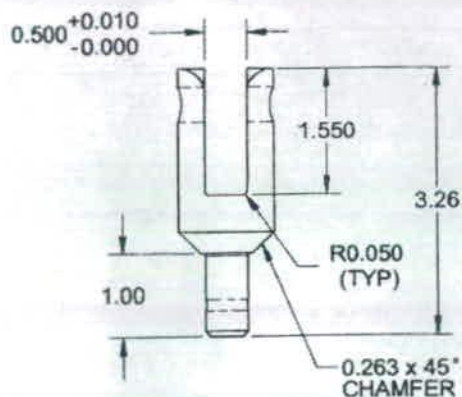
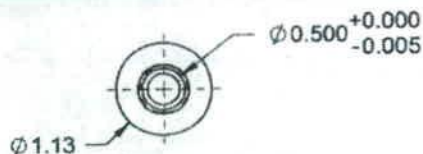
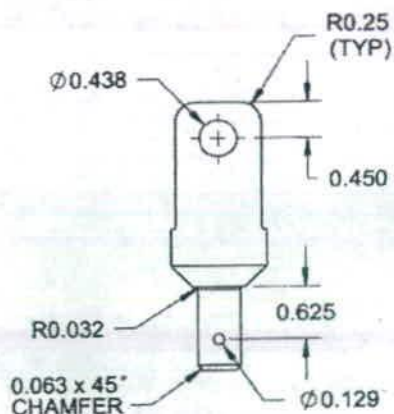
*U 06/09/11*



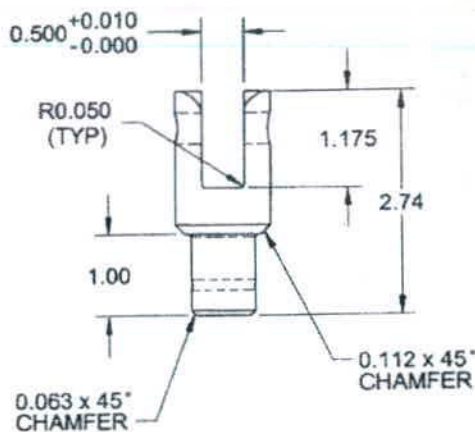
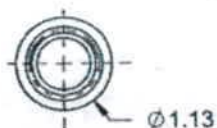
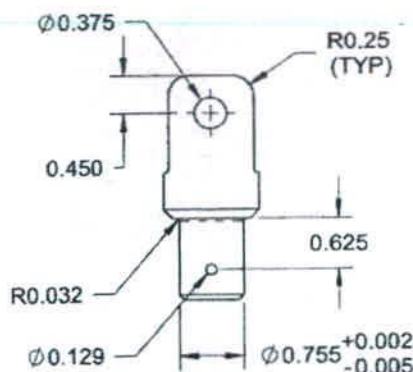


**DART**

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3453	REV. A SHEET 1 OF 2
DATE 05.09.02	TITLE CLEVIS		SCALE 1:2
A	05.09.02	NEW ISSUE	

**D3453-1 CLEVIS****RELEASED**

05.12.09

**D3453-3 CLEVIS****REFERENCE ONLY****NOTES:**

- 1) MATERIAL: AISI 304 SS ROUND BAR (REF. DART SPEC M304R)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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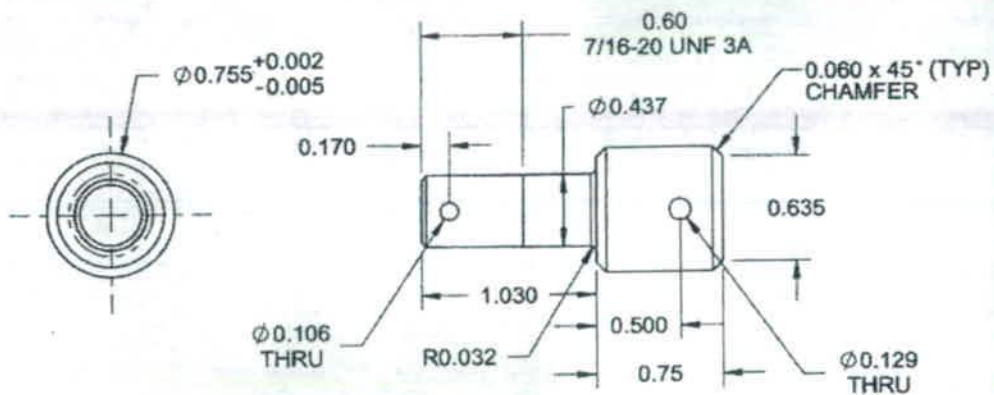


**DART**

DESIGN RF	DRAWN BY RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. <b>D3453</b>	REV. A SHEET 2 OF 2
DATE <b>05.09.02</b>	TITLE <b>CLEVIS</b>		SCALE 1:1

**RELEASED**

05.12.09 [Signature]

**D3453-5 PLUG****NOTES:**

- 1) MATERIAL: AISI 304 SS ROUND BAR (REF. DART SPEC. M304R)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/09/08	6	1 piece scrap, the drill broke inside the piece.		Scrap & destroy	 06/09/08	 06-09-08		 06-09-08

NOTE: Date & initial all entries

